

Work Order ID 63583

Thursday, November 04, 2010 1:06:01 PM



Page 1

Item ID:	D2933-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle LH In, 206					
Start Date:	11/4/2010	Start Qty:	6.00		Cust Item ID:	
Required Date:	11/12/2010	Req'd Qty:	6.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-11-04	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2933	Rev C								

100		HAAS CNC VERTICAL MACHINING #1	0.00						
HAAS 1		Memo	0.00		10.12.3				

HAAS CNC vertical machine #1
 Program part number and batch number. ☐ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110		CONVENTIONAL MILLING MACHINE	0.00						
Mill Conv		Memo	0.00		10.12.3				

Conventional Milling Machine.
 Machine Keyway and inspect per attached dimension sheet

120		QC1- Inspect dimensions to dimension sheet	0.00						
QC		Memo	0.00		10.12.3				

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 11/4/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		A.A 10/12/06		6	0		
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		→ JH 10/12/06		6	0		
150 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 115951 Memo START TIME: 10:00 3:30 FINISH TIME: 10:30	0.00 0.00				6		BR 10.12-7.	

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Page 3

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Accept

Setup Start

Revision ID:

Stop

Item Name: Saddle LH In, 206

Start Date: 11/4/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00

⇒ M 10/12/07

6

0



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: 428

0.00



Packaging

Memo

0.00

Packaging

10/12/08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08
CMF
10-12-08

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, November 04, 2010 1:06:05 PM

Page 1

Work Order ID: 63583

Parent Item: D2933-1

Parent Item Name: Saddle LH In, 206



Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B 00.06.26 New DWG rev (mpp 2069) EC
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	2.0000	1	6			

Saddle Billet

Location

Loc Qty

Loc Code

MAT40

2

61385

2

63583

(xc)

ent 10/12/03

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	63583
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK:		Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5	6
A	0.100	0.140	✓ Vernier	.120	.120	.120	.120	.120	.120
B	0.100	0.140	✓ - 02	.120	.120	.120	.120	.120	.120
C	0.100	0.140		.125	.125	.125	.125	.125	.125
D	0.210	0.230		.220	.220	.220	.220	.220	.220
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.513	.513	.513	.513	.513	.513
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257	.257
L	0.312	0.317		.314	.314	.314	.314	.314	.314
M	0.235	0.240		.237	.237	.237	.237	.237	.237
N	0.100	0.140		.115	.115	.115	.115	.115	.115
O	0.540	0.560		.550	.550	.550	.550	.550	.550
P	0.490	0.510		.502	.502	.502	.502	.502	.502
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.491	2.491	2.491	2.491	2.491	2.491
S	0.240	0.270		.250	.250	.250	.250	.250	.250
T	0.100	0.180		.122	.122	.122	.122	.122	.122
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188	.188
AA									
AB									
AC									
AD									
AE									
Accept/Reject									

Measured by:	MR	Date:	10-12-3
Audited by:	A. A	Date:	10/12/06
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

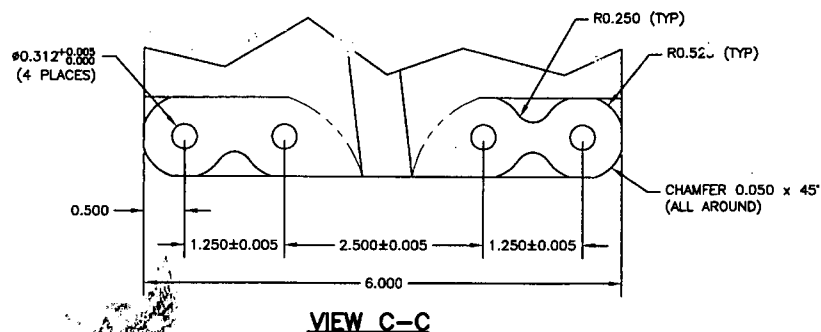
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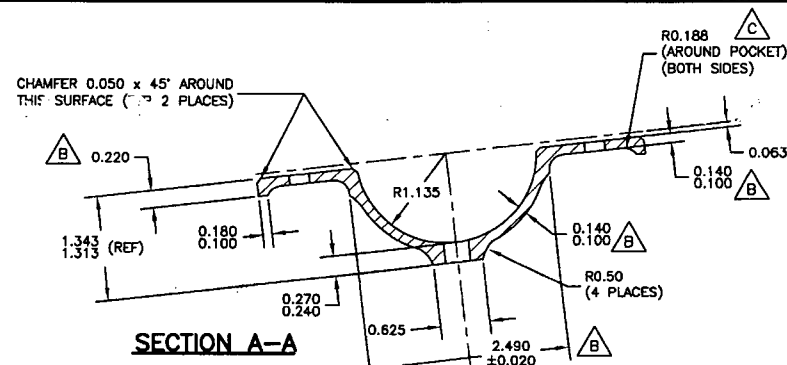
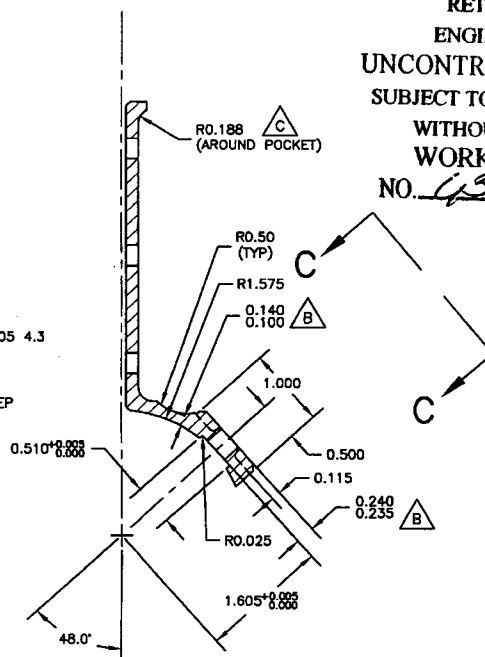
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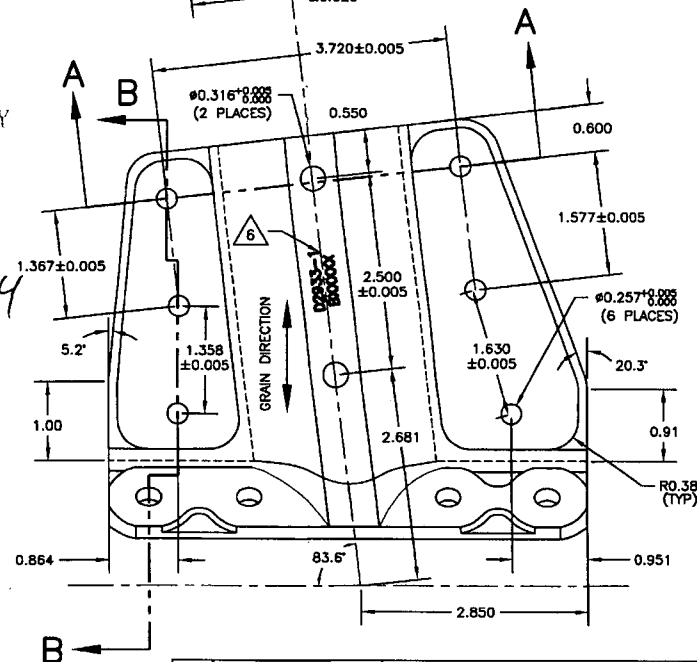
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

- NOTES:**
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D8101-001 SADDLE BILLET, 7075)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 - 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 43588

01-11-04



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	
CHECKED	APPROVED	
DATE	TITLE	
06.11.09	SADDLE INSIDE	

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 DART AEROSPACE USA, INC.

DART DART AEROSPACE USA, INC.
 BELLEVUE, WA

DRAWING NO.
D2933
 SHEET 1 OF 1
 SCALE
 2:3

W/O:		WORK ORDER CHANGES					
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